

Work Order ID 57846

Friday, April 16, 2010 2:42:45 PM



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Item Name: Light Lid Assembly, Long Basket

Stop



Start Date: 4/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-4-16 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3915	B								
100	Weld per dwg A/R Aluminum rod Batch: <i>M11131</i> 0.00 Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3915 ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

*10-04-20**① 10 04.21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

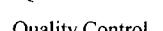
Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC5- Inspect part completeness to step on W/O

QC



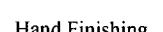
Quality Control

130



✓ Chemical Conversion Coat per QSI005 4.1

HandFinish



Hand Finishing

Memo

0.00

S 10/04/22

0.00

140

Weld per dwg A/R Aluminum rod Batch: M111311 0.00

Large Fab



Memo

0.00

1-weld (4) corners

0.00

0.00

0.00

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Required Date: 4/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

(1) PD 10.04.22

155



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

S. Walz

Memo

inspect fit of lid with base

0.00

(X1)

156. S. Walz Re Aluding ^{corners} for QSI 005
 16/04/22

~~W.P.~~ ~~Q.S.~~ Jef 16/04/22 (X1)

W/O: 57846		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.04.22	15b	Proc Change ADD step to re-aligning comms. Per QSI005	A	10.04.26			S 10/04/22

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

=> M 10/04/22

1

6

Powder Coating

1- touch up corner with alodine only
 2- Plug holes prior to

1ST COAT:

START TIME: 1:30pm

OVEN TEMPERATURE: 320° F

FINISH TIME: 2:00pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE: 210° F

FINISH TIME: 2:30pm

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

D BR0-4-22

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



HandFinish

Assemble as per dwg

0.00

Hand Finishing

Memo

0.00

S 16/04/23

1- Install webbing as per dwg

2- Install placard and label as per dwg

190



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S 16/04/23

200



Identify as per dwg & Stock Location:

0.00

Packaging

Packaging

wl05742
Memo

0.00

D4030-043

S 16/04/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Required Date: 4/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/04/23 JF

MF
10-4-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, April 16, 2010 2:42:44 PM

Page 1

Work Order ID: 57846



Parent Item: D3915-041



Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 4/16/2010

Required Date: 4/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2957 		Manufactured	No			100	Each	33.0000	4.0000		<i>4/10.04.19</i>	

Mounting Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	33
56660	1
57088	12
<u>57697</u>	20

D3915-1

Rib Manufactured No

100 Each 6.0000 2.0000



4/10.04.19

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	6
57089	4
<u>57297</u>	2

4/10.04.19

2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 2

Friday, April 16, 2010 2:42:44 PM

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Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 4/16/2010

Required Date: 4/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D4016-5



Manufactured

No

100

Each

19.0000

3.0000



Hinge Half, Light Lid

4/10-04-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

ENG

2



56075

2



Main Warehouse

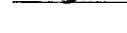
ST109

13



57293

13



Main Warehouse

WA

4



56951

4



D4019-3



Manufactured

No

100

Each

9.0000

3.0000



Rib

4/10-04-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

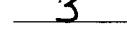
WA

9



57090

6



57296

3



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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D4035-045		Manufactured	No		100	Each	3.0000	1.0000			<i>PL 10.04.19</i>
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Lid Rib Assembly, Fwd (Light)

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

3

56972

57295

2

1

D4035-047

Manufactured	No	100	Each	3.0000	1.0000
--------------	----	-----	------	--------	--------

Lid Rib Assembly, Aft (Light)

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

3

56977

57294

2

1

D4056-1

Manufactured	No	100	Each	5.0000	1.0000
--------------	----	-----	------	--------	--------

Label Plate

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

5

56661

56938

2

3

W/O:		WORK ORDER CHANGES							
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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2728-1		Manufactured	No			180	Each	0.0000	1.0000		S8 10/04/22	
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Dart Logo label

D4029-041		Manufactured	No			180	Each	3.0000	1.0000			
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Webbing (Long Basket)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Warehouse <u>Location</u>	Loc Qty	Loc Code

D2728-1		Manufactured	No			180	Each	0.0000	1.0000				
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Placard, Max Load

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Warehouse <u>Location</u>	Loc Qty	Loc Code

D4086-220		Manufactured	No			180	Each	7.0000	1.0000				
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Warehouse <u>Location</u>	Loc Qty	Loc Code

D4086-220		Manufactured	No			180	Each	7.0000	1.0000				
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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W3	AD4W3	Purchased		No		180	Each	728.0000	34.0000			

Blind Rivet

B

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST321	728	
111477	428	
114382	300	

SD 10/04/22 PM

NAS1149DN416J	Purchased	No		180	Each	304.0000	34.0000					

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
13910	4	
Main Warehouse		
ST275	200	
114340	200	
Main Warehouse		
ST298	100	
114348	100	

81 10/04/22

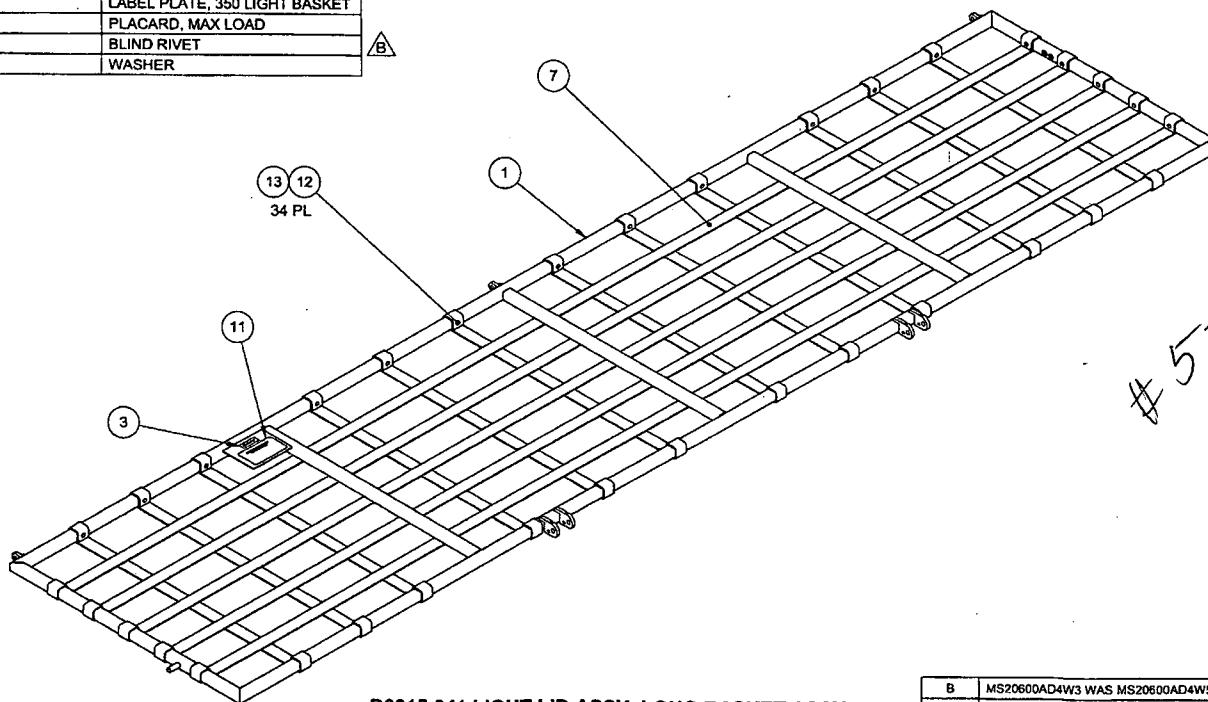
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/22	100	MS20600AD4-5 was change for MS20600AD4-3 <u>M</u>			34		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W3	BLIND RIVET
13	34		NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

A NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 6.91 lbs

B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3915	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LIGHT LID ASSY-LONG BASKET	
DATE	10.04.06	NTS	

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8 7 6 5 4 3 2 1

D

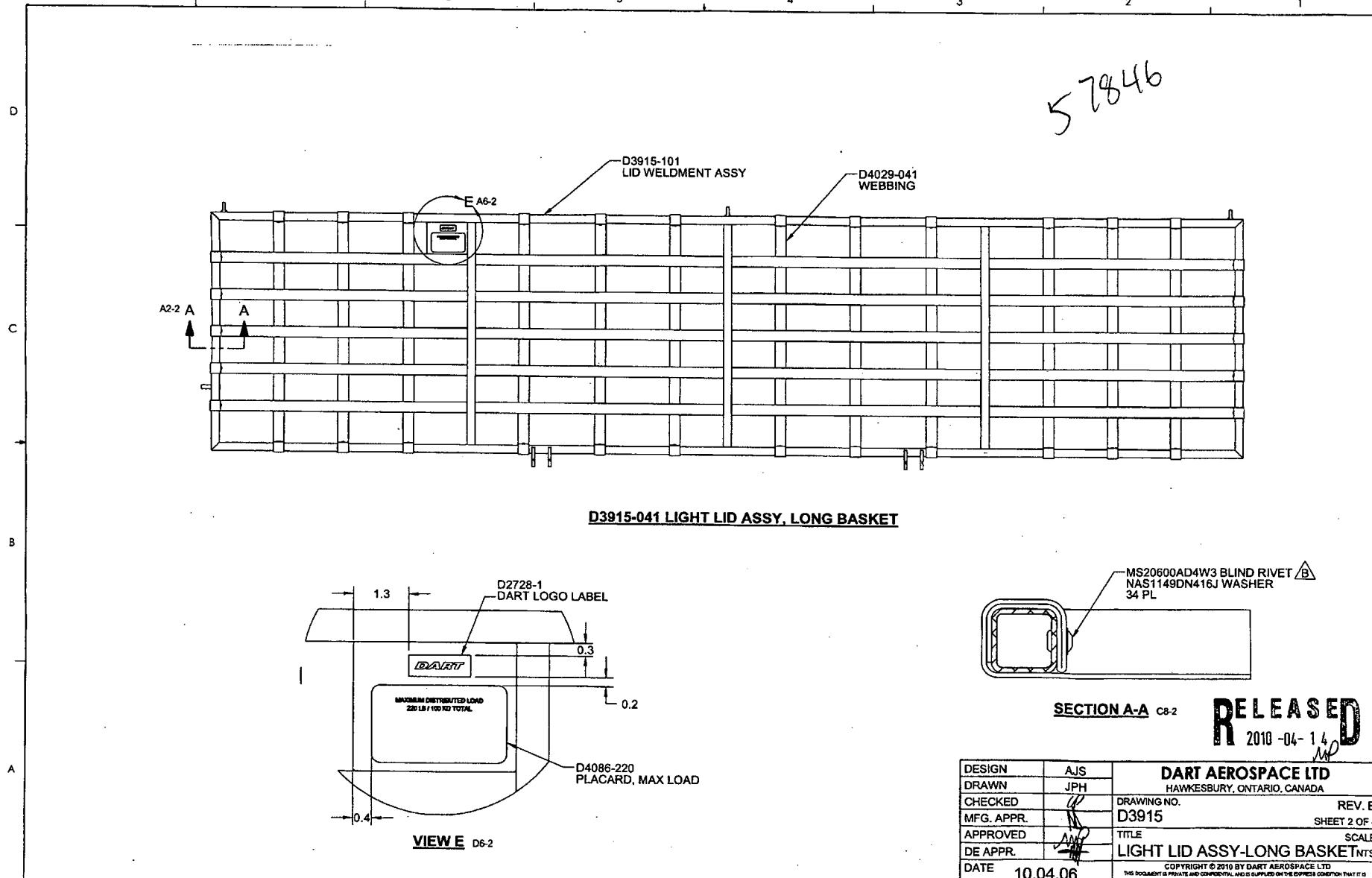
C

B

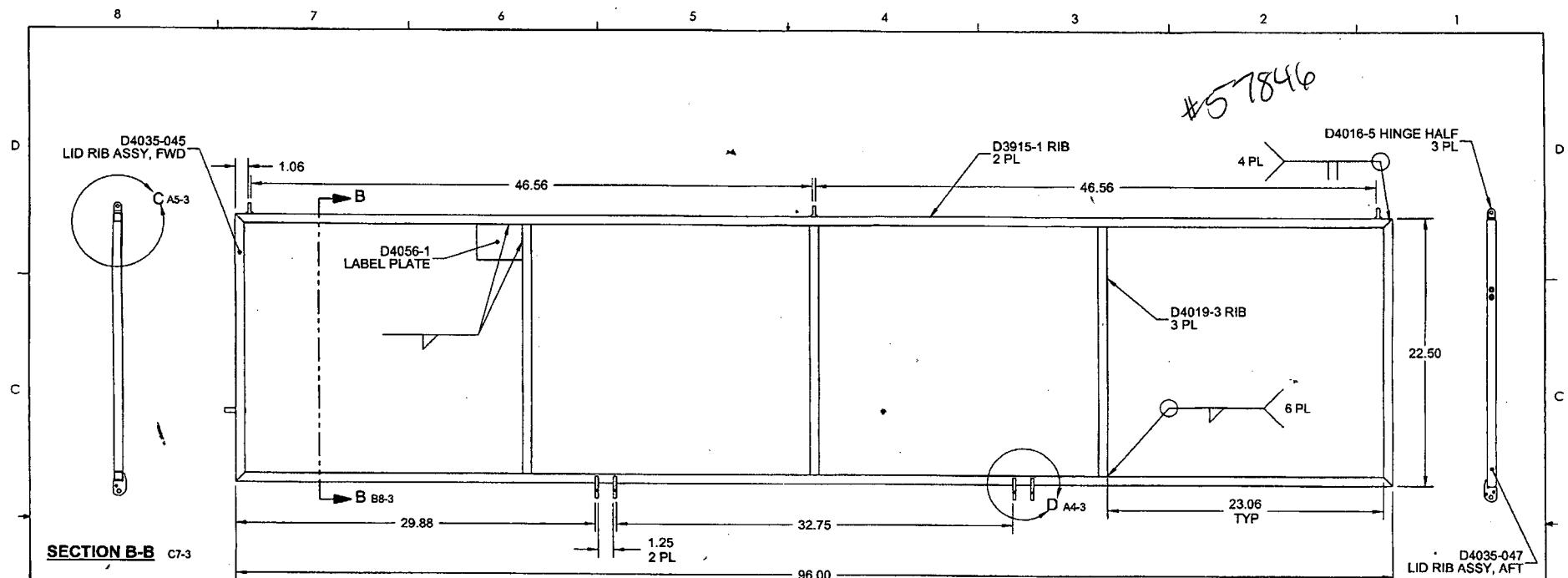
A

I

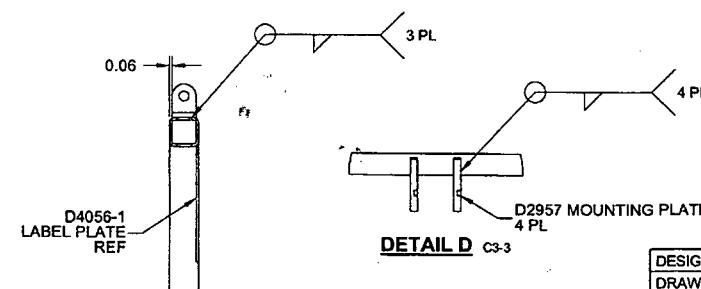
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



D3915-101 BASKET LID WELDMENT ASSY ASSY



DETAIL C C8-3

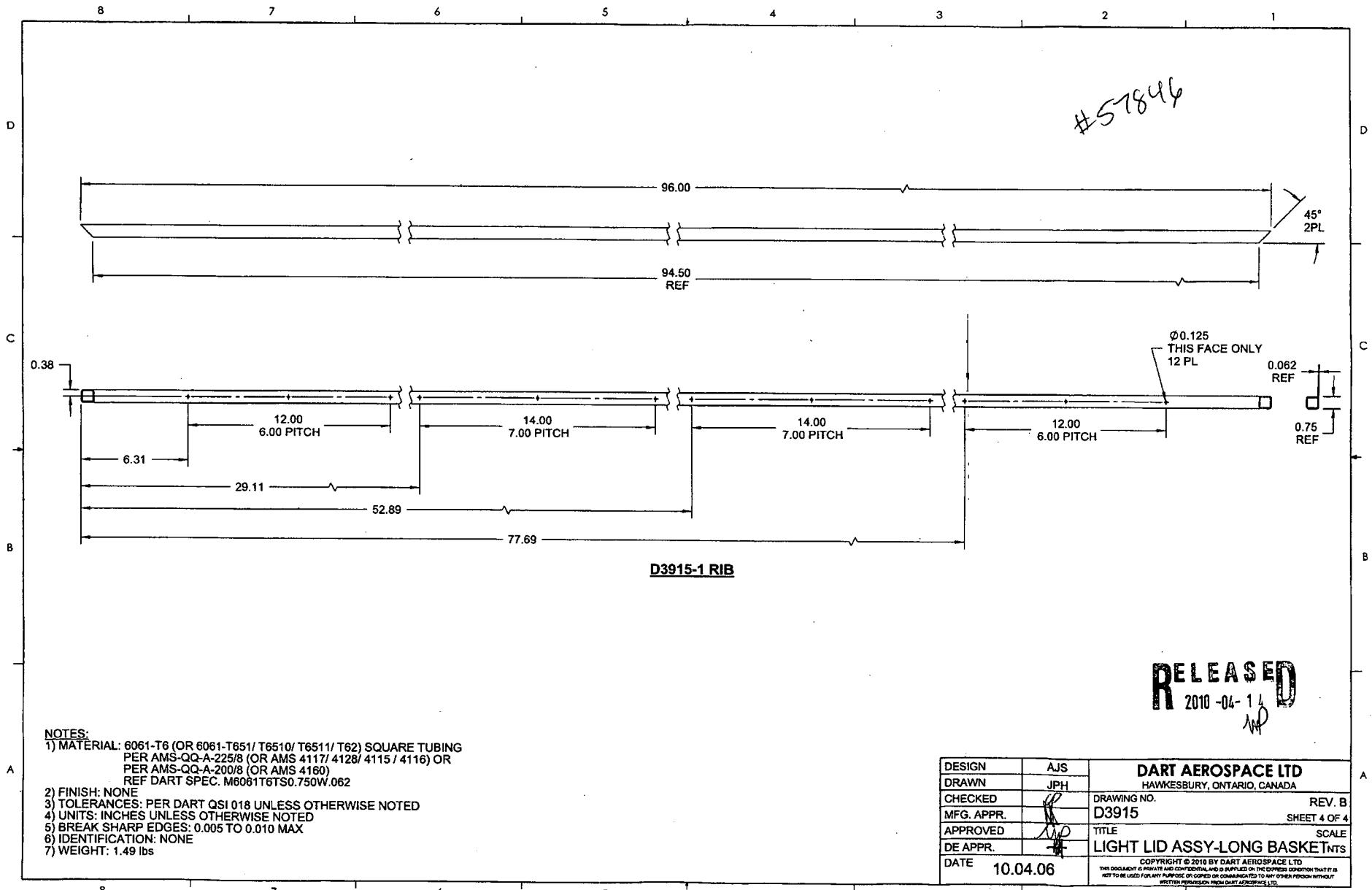
DETAIL D C3-3

NOTES:
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 4.81 lbs
 8) WELD PER DART QSI 004

RELEASED
2010-04-14
JP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3915	
APPROVED		REV. B	
DE APPR.		SHEET 3 OF 4	
DATE	10.04.06	TITLE	SCALE
		LIGHT LID ASSY-LONG BASKET	

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2010-04-14
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